

Work Order ID 161241

Tuesday, May 09, 2017 10:23:15 AM

161241

Page 1

Item ID: D3440-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp (Supersedes B67-43001-309)
Start Date: 5/10/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 5/17/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED/S
Approvals: Process Plan:  Date: MAY 09 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3440	B								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 3.950" long

101.3

110

0.16

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

1.40

HAAS CNC vertical machine #1

Machine as per Folio FA538 and Dwg D3440 Dwg Rev: B Identify as
D3440-3 Folio Rev: A Deburr

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

5

5

5

P17-05-09

P17-05-09

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>5</u>	<u>2</u>		DAS 44 9-89 17-05-11
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 1.19				<u>(5)</u>	<u>0</u>		2017/05/11 BETB.
150 *150* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <u>m B4092.</u> Memo START TIME: <u>9:35</u> <u>220°</u> FINISH TIME: <u>10:05</u>	0.00 0.35				<u>5</u>	<u>0</u>	<u>170519</u>	9-89 34

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Item ID: D3440-3 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 5/10/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 5/17/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				5			DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									MAY 19 2017
170	Identify as per dwg & Stock Location: <u>WA003</u>	0.00				5			
170									
Packaging	Memo	0.00							DAS 6 9-89
Packaging									MAY 24 2017
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									17/5/25 JF MAY 24 2017

Picklist Print

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Page 1

Work Order ID: 161241

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Parent Item: D3440-3

D3440-3

Parent Item Name: Clamp (Supersedes B67-43001-309)

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP A05.07.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	9.9800	0.3292	1.732632			

M6061T6B1 250X01 250

6061-T6 Bar 1.25 x 1.25

Location

Loc Qty

Loc Code

MAT003

9.98

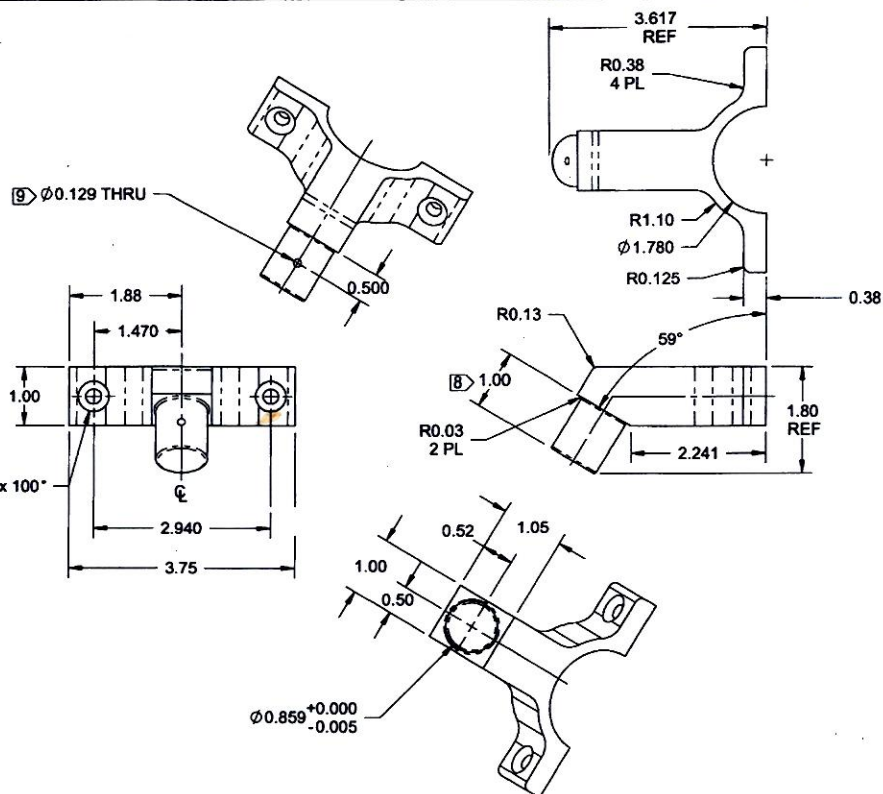
m135377

0.667

m136327

9.313

16675' 817-05-09



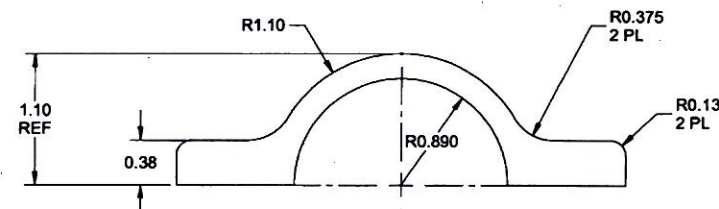
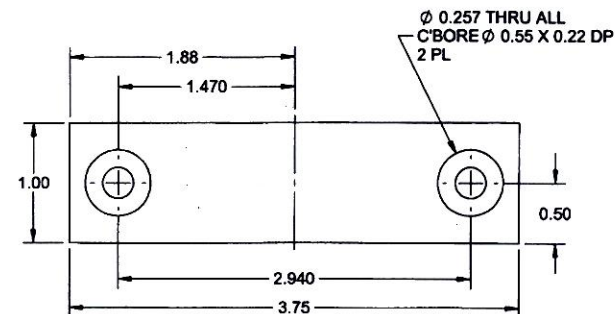
D3440-1 TUBE GUIDE
SUPERSEDES PREMIER P/N B67-43001-251-307

D3440-1-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QT-A/200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N D3440-X PER DART QSI 044 6.1
- 7) WEIGHT: D3440-1=0.35 lb
D3440-3=0.11 lb
- 8) MASK BEFORE PAINTING.
- 9) DRILL HOLE AT ASSEMBLY.

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WITHOUT NOTICE
WORK ORDER
NO. 1612410

MAY 09 2017

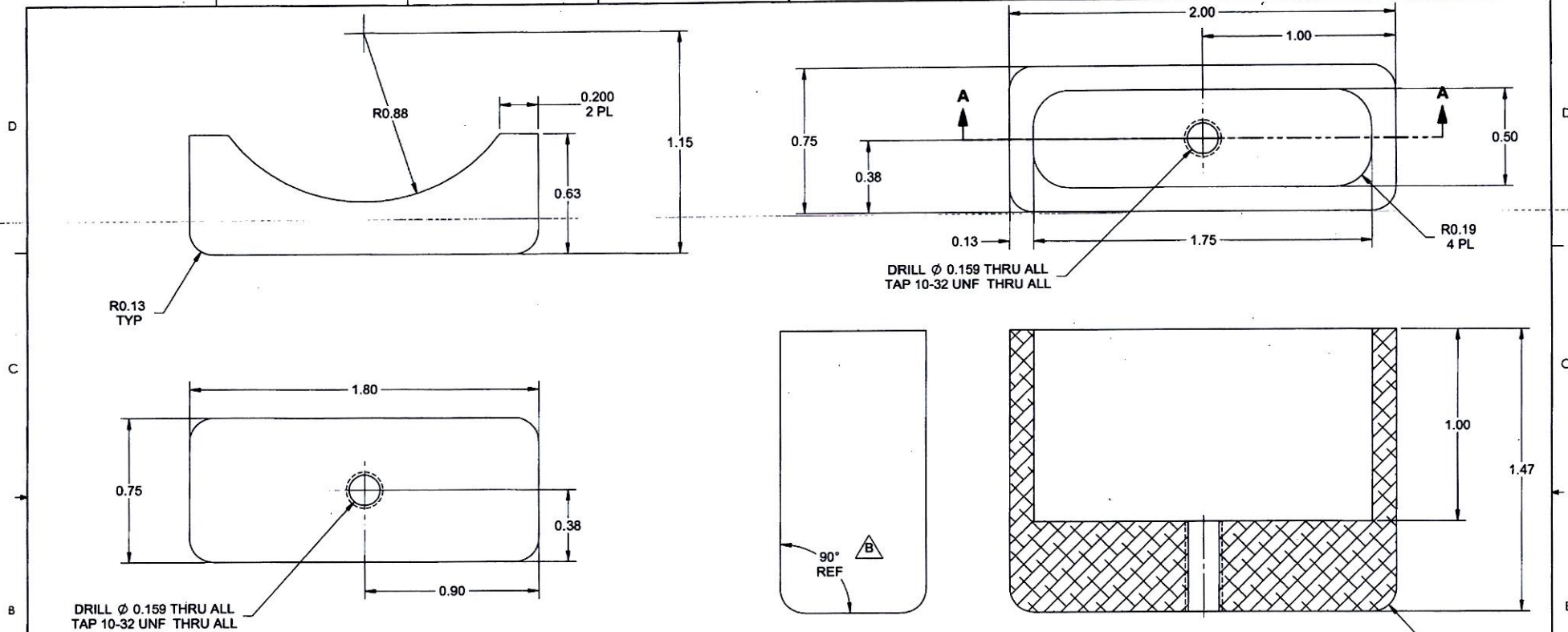


D3440-3 CLAMP
SUPERSEDES PREMIER P/N B67-43001-309

RELEASED
2014-12-08

B	RE-FORMAT DWG TO CURRENT STANDARD, 90° WAS 93° (ZIN B4-2), 0.132 DEEP WAS 0.085 DEEP (ZIN C4-4) REASON-FACILITATE MANUFACTURING	DB	14.07.22
A	NEW ISSUE	MB	05.06.02
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	MB	D3440	SHEET 1 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	BLADE FOLD KIT PARTS	NTS
DATE	14.07.22	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D3440-5 CONTOURED DETENT CLIP BASE
SUPERCEDES PREMIER P/N B67-43001-217

D3440-7 DETENT CLIP BASE
SUPERCEDES PREMIER P/N B67-43001-221

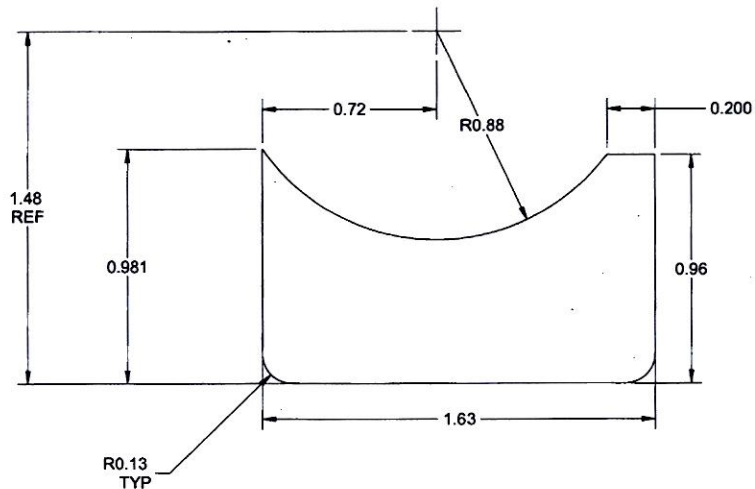
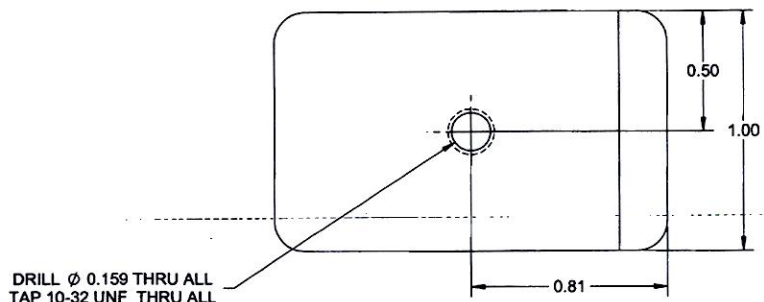
SECTION A-A

D3440-5/7 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR PER AMS/AA/200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
 REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3440-5=0.05 lb
 D3440-7=0.13 lb

RELEASED
 2014-12-08

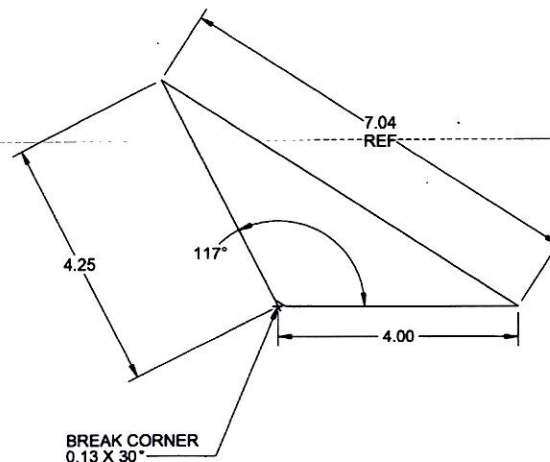
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DRAWN	DB		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3440	SHEET 2 OF 4
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D3440-9 TUBE DETENT CLIP BASE
SUPERCEDES PREMIER P/N B67-43001-241

D3440-9 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.11 lb



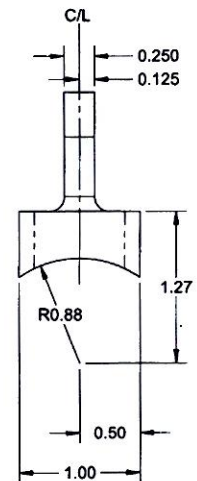
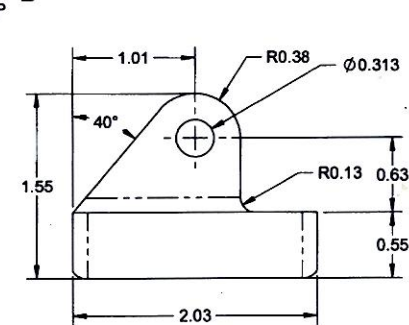
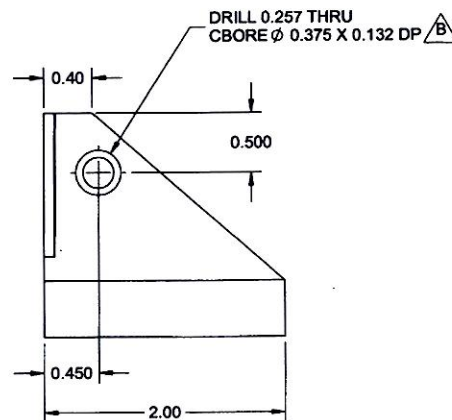
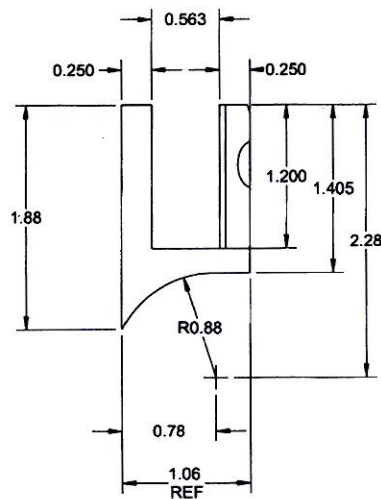
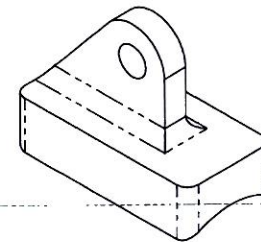
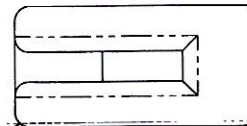
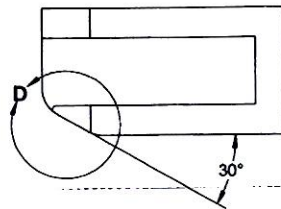
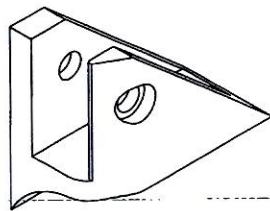
D3440-11 GUSSET

D3440-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lb

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2014-12-08

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.		D3440	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.	JS	BLADE FOLD KIT PARTS	NTS
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D3440-13 BRACKET
SUPERCEDES PREMIER P/N B67-43001-273

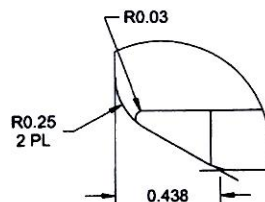
D3440-15 CONTOURED MALE EYE
SUPERCEDES PREMIER P/N B67-43001-215

RELEASED
2014-12-08

D3440-13/-15 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ-A/200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3440-13=0.11 lb
D3440-15=0.11 lb

DETAIL D
SCALE 2X



DESIGN	MB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
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APPROVED	h	TITLE	SCALE
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